

Work Order ID 58777

Tuesday, May 18, 2010 3:09:22 PM



Page 1

Item ID: D4030-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Assembly (350)

Start Date: 5/18/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/28/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: MPDate: 10-5-18 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4030

B

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

10-5-21 SP

110

Assemble as per dwg

0.00



HandFinish

Memo

0.00

Hand Finishing

ES 10/05/26 ①

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 idast26④

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D4030-041

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Setup Start



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Stop



Start Date: 5/18/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/28/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

PPP 5877

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/2010

CL 10/5/2010

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Page 1

Work Order ID: 58777

Parent Item: D4030-041

Parent Item Name: Long Basket Assembly (350)

Comments: IPP Rev:A new issue DD 10.03.23 verified by:EC
per dwg revB DD 10.04.20 verified by:EC






IPP Rev:B as

Start Date: 5/18/2010

Required Date: 5/28/2010

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D2530  Handle Weldment		Manufactured	No			100	Each	6.0000	1		10-5-21	S
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST506		6						
				57736		1						
				57964		5						
D2535  Spring		Manufactured	No			100	Each	148.0000	2		10-5-21	sf
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST504		148						
				56355		48						
				58331		100						
D2537  Bushing		Manufactured	No			100	Each	65.0000	4		10-5-21	sf
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>				
				ST504		65						
				53181		5						
				57722		20						
				58429		40						
D3913-041  Long Basket Base Assembly, 350		Manufactured	No			100	Each	0.0000	1		B58660 (1x) 5/50/05/26	
D3914-041  Long Basket Lid Assembly (350)		Manufactured	No			100	Each	0.0000	1		B58661 (1x) 5/50/05/26	

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 Washer		Manufactured	No			100	Each	24.0000	6		5/20/05/26	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>			
				ST096				24				
					57144			1				
					58186			23				
D3953-3  Gas Spring Stud, Lid		Manufactured	No			100	Each	1.0000	2		10-5-21	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>			
				ST101				1				
					57978			1				
D3953-7  Spring Spacer		Manufactured	No			100	Each	9.0000	2		10-5-21	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>			
				ST101				9				
					53970			9				
D3953-9  Gas Spring Washer		Manufactured	No			100	Each	26.0000	2		10-5-21	
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>			
				ST101				26				
					53642			26				

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Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D3953-17  Gas Spring Spacer		Manufactured	No			100	Each	2.0000	2		10-5-21	SP


Location Loc Qty Loc Code

ST101 2
57143 2

D3953-19  Gas Spring Bracket		Manufactured	No			100	Each	11.0000	1		10-5-21	SP
---	--	--------------	----	--	--	-----	------	---------	---	--	---------	----


Location Loc Qty Loc Code

ST101 11
57607 11

D3953-21  Gas Spring Bracket		Manufactured	No			100	Each	19.0000	1		10-5-21	SP
---	--	--------------	----	--	--	-----	------	---------	---	--	---------	----

Location Loc Qty Loc Code

ENG 6
56407 6
ST102 13
57145 13

D3969-3  Spring (Basket Lid)		Manufactured	No			100	Each	0.0000	1		1	88 6/05/26
---	--	--------------	----	--	--	-----	------	--------	---	--	---	------------

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Start Date: 5/18/2010

Required Date: 5/28/2010



Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
AN3-14A  Bolt		Purchased	No			100	Each	86.0000	4	10-5-21		

Location	Loc Qty	Loc Code
ST351	86	



114330

AN3-16A  Bolt		Purchased	No			100	Each	69.0000	2	10-5-21		
--	--	-----------	----	--	--	-----	------	---------	---	---------	--	---

Location	Loc Qty	Loc Code
ST352	69	

113845

114523

AN5-17A  Bolt		Purchased	No			100	Each	159.0000	4	10-5-21		
--	--	-----------	----	--	--	-----	------	----------	---	---------	--	---


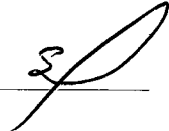
Location	Loc Qty	Loc Code
ST323	54	

114324

ST339

113538

114330

AN4-12  Bolt		Purchased	No			100	Each	44.0000	3	10-5-21		
---	--	-----------	----	--	--	-----	------	---------	---	---------	--	---

Location	Loc Qty	Loc Code
ST357	44	

114292

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IPP Rev:B as

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
AN310-4		Purchased	No			100	Each	55.0000	3			
												
NUT												

Location Loc Qty Loc Code

ST139 30

114341 30

ST314 5

113845 5

ST349 20

114341 20

AN310C4 Purchased No



Nut

100 Each 76.0000



Location Loc Qty Loc Code

ST349 76

114306 76

MS21042L3 Purchased No



Nut

100 Each 1,426.000



Location Loc Qty Loc Code

ST300 1426

113537 20

113644 406

114523 1000

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IPP Rev:B as

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
MS21042L5		Purchased	No			100	Each	565.0000	4			
Nut												

Location	Loc Qty	Loc Code
ST300	565	
113523	26	
113537	3	
114108	36	
114437	100	
114449	400	

MS24665-151		Purchased	No			100	Each	686.0000	3			
Cotter Pin												

Location	Loc Qty	Loc Code
ST309	686	
17566	686	

MS24665-300		Purchased	No			100	Each	86.0000	2			
Cotter Pin												

Location	Loc Qty	Loc Code
ST309	86	
105279	2	
110123	84	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 7

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Start Date: 5/18/2010


Required Date: 5/28/2010

Start Qty: 1.00


Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
NAS1149F0432P		Purchased	No			100	Each	347.0000	6			
												
Washer												


Location	Loc Qty	Loc Code
ST275	347	
112940	92	
114405	1	
114576	254	

NAS1149F0563P		Purchased	No			100	Each	260.0000	4			
												
Washer												

Location	Loc Qty	Loc Code
ST275	60	
108471	60	
ST298	200	
114576	200	

NAS1149F0332P		Purchased	No			100	Each	887.0000	8			
												
WASHER												

Location	Loc Qty	Loc Code
ST275	887	
18057	887	

NAS1149C0432R		Purchased	No			100	Each	182.0000	2			
												
Washer												

Location	Loc Qty	Loc Code
ST297	182	
114292	182	

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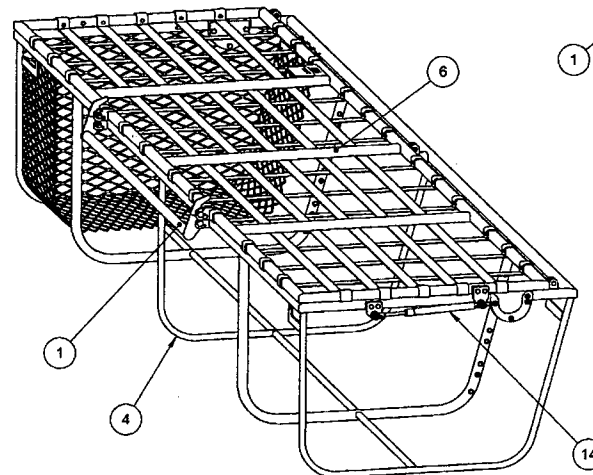
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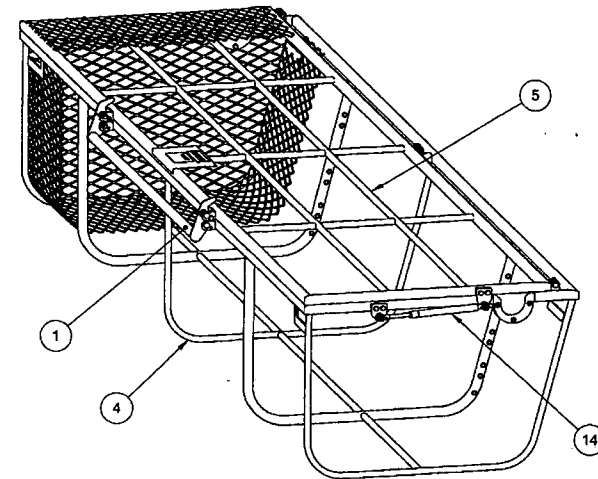
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ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4030-041	LONG BASKET ASSY (350)
		X	D4030-043	LONG BASKET ASSY, LIGHT LID (350)
1	1	1	D2530	HANDLE WELDMENT
2	2	2	D2535	SPRING
3	4	4	D2537	BUSHING
4	1	1	D3913-041	LONG BASKET BASE ASSY (350)
5	1		D3914-041	LONG BASKET LID ASSY (350)
6		1	D3915-041	LIGHT LID ASSY-LONG BASKET
7	6	6	D3917-3	WASHER
8	2	2	D3953-3	GAS SPRING STUD, LID
9	2	2	D3953-7	GAS SPRING SPACER
10	2	2	D3953-9	GAS SPRING WASHER
11	2	2	D3953-17	GAS SPRING SPACER
12	1	1	D3953-19	GAS SPRING BRACKET
13	1	1	D3953-21	GAS SPRING BRACKET
14	1	1	D3969-3	SPRING
15	4	4	AN3-14A	BOLT
16	2		AN3-16A	BOLT
17		2	AN3-20A	BOLT
18	3	3	AN4-12	BOLT (DRILLED)
19	4	2	AN5-17A	BOLT
20		2	AN5-21A	BOLT
21	3	3	AN310-4	NUT, CASTELLATED
22	2	2	AN310C4	NUT, CASTELLATED
23	6	6	MS21042L3	NUT
24	4	4	MS21042L5	NUT
25	3	3	MS24665-151	COTTER PIN
26	2	2	MS24665-300	COTTER PIN
27	6	6	NAS1149F0432P	WASHER
28	4	4	NAS1149F0563P	WASHER
30	8		NAS1149F0332P	WASHER
31	2		NAS1149C0432R	WASHER



D4030-043 LONG BASKET ASSY, LIGHT LID (350)
(MESH SHOWN LOCALLY FOR CLARITY)



D4030-041 LONG BASKET ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: -041: 72 lbs APPROX
-043: 57 lbs APPROX

RELEASED
2010-04-14
MP

B	AN5-21A BOLT WAS AN5-19A: BOM & (D3-3)	JPH	10.04.06
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	GR	DRAWING NO.	REV. B
MFG. APPR.	KPS	D4030	SHEET 1 OF 3
APPROVED	AMP	TITLE	SCALE
DE APPR.	MP	LONG BASKET ASSY (350)	NTS
DATE	10.04.06	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

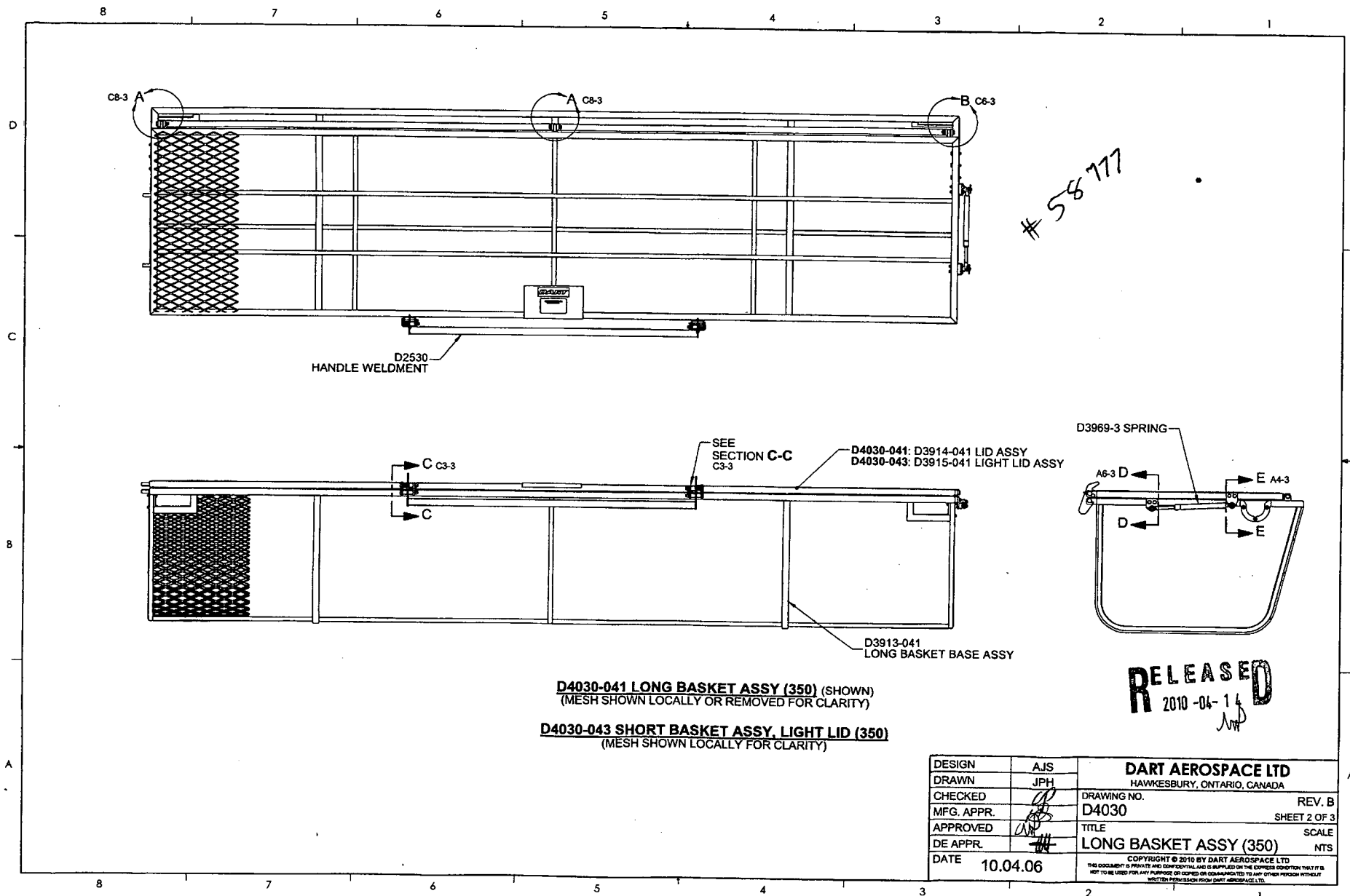
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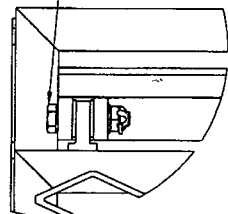
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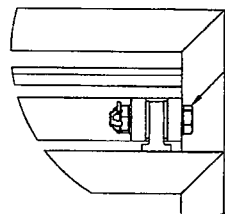
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AN4-12 BOLT
D3917-3 WASHER, 2X
NAS1149F0432P WASHER, 2X
AN310-4 NUT, CASTELLATED
MS24665-151 COTTER PIN

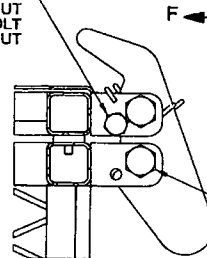


DETAIL A D8-2
D5-2



DETAIL B D3-2

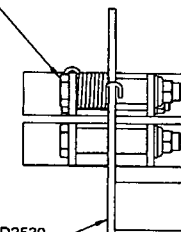
D4030-041: AN3-16A BOLT
MS21042L3 NUT
D4030-043: AN3-20A BOLT
MS21042L3 NUT



SECTION C-C B4-2
B6-2

D4030-041: AN5-17A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT

D4030-043: AN5-21A BOLT
D2537 BUSHING
D2535 SPRING
NAS1149F0563P WASHER
MS21042L5 NUT



VIEW F-F C3-3

D2530
HANDLE WELDMENT
REF

D3953-17 GAS SPRING SPACER
D3953-21 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION D-D B2-2

D3953-17 GAS SPRING SPACER
D3953-19 GAS SPRING BRACKET
AN3-14A BOLT
NAS1149F0332P WASHER, 2X
MS21042L3 NUT
2 PL

D3953-3 GAS SPRING STUD, LID
D3953-7 GAS SPRING SPACER
D3953-9 GAS SPRING SPACER
NAS1149C0432R WASHER
AN310C4 NUT, CASTELLATED
MS24665-300 COTTER PIN

D3969-3 SPRING
REF

SECTION E-E B1-2

RELEASED
2010-04-14
JMP

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	GP	DRAWING NO.	REV. B
MFG. APPR.	JPH	D4030	SHEET 3 OF 3
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	LONG BASKET ASSY (350)	NTS
DATE	10.04.06	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries